



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200

644.4101-F
Job Sheet 175555



Part No: 644.4101-F

Job Qty: 10 ea

Part Name: Pivot Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 5/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 644.4100 Rev F2 IPP Rev B 18.04.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	10 Ea	5/8/18	5/8/18	0.00	0.00	Start Up Small Fab-4		JUN 12 2018
110	Small Fab	10 pcs	5/9/18	5/9/18	0.00	10.00	Small Fab-8		DAB
120	QC	10 pcs	5/9/18	5/9/18	0.00	0.00	QC5		38
130	Packaging	10 pcs	5/9/18	5/9/18	0.00	0.00	Packaging3		JUN 14 2018
140	QC21-FG	10 Ea	5/9/18	5/9/18	0.00	0.00	QC21		18-08-14

Part Op 110 - ASSEMBLE BRACKETS AS PER DWG
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
644.4103	Aft Bracket Assembly	10 Ea (1 ea)	100-Start up Operation	5050773
644.4110	Aft Bracket, Large	10 Ea (1 ea)	100-Start up Operation	5057866
644.4112	Spacer	20 Ea (2 ea)	100-Start up Operation	5067873
644.4113	Spacer, Stop	20 Ea (2 ea)	100-Start up Operation	5068135
644.4118	Washer, Nylon	20 Ea (2 ea)	100-Start up Operation	5068875
644.4120	Spacer, Crosstube	10 Ea (1 ea)	100-Start up Operation	5067668
AN310-4	Nut	10 Ea (1 ea)	100-Start up Operation	5060062
AN4-45	Bolt	10 Ea (1 ea)	100-Start up Operation	5060053
AN4-47A	Bolt	10 Ea (1 ea)	100-Start up Operation	5061375580
AN5-43A	Bolt	20 Ea (2 ea)	100-Start up Operation	507727119
MS21044N4	Nut, Self-Locking	10 Ea (1 ea)	100-Start up Operation	5061119
MS21044N5	Nut	20 Ea (2 ea)	100-Start up Operation	507526x12 507526 1x2
MS24665-132	Cotter Pins	10 Ea (1 ea)	100-Start up Operation	FM136349-410
NAS1149C0463R	Washer	40 Ea (4 ea)	100-Start up Operation	5077381x39 503445x
NAS1149C0563R	Washer	40 Ea (4 ea)	100-Start up Operation	FM138408-2100

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	644.4103	10	0	0
	644.4110	10	0	0
	644.4112	20	0	0
	644.4113	20	0	0
	644.4118	20	0	0
	644.4120	10	0	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition																			

Container No: S080731
 Part: 644.4101
 Job No: 175555
 Serial No/Batch: S080731
 Revision: F2
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 06/13/18

Root Cause		FAULT CATEGORY	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐		

AN310-4	10	81	0
AN4-45	10	6	0
AN4-47A	10	13	0
AN5-43A	20	20	0
MS21044N4	10	58	0
MS21044N5	20	115	0
MS24665-132	10	281	0
NAS1149C0463R	40	324	0
NAS1149C0563R	40	176	0

Part Specifications

Specifications could not be found.

Plex 4/6/18 11:07 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					